

Date: Tuesday, 03/04/2007 3:20:23 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: PIN
Job Number	: 31578		
Estimate Number	: 12672		
P.O. Number	: N/A	Part Number	: D31471
This Issue	: 03/04/2007	Drawing Number	: D3147 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 30824	Material	: N/A
Written By		Due Date	: 10/04/2007
Checked & Approved By		Qty:	3
Comment	Um: Each Est Rev A New Issue 07-01-26 JLM		

Additional Product

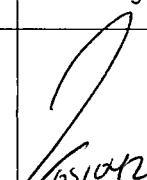
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0187	303 Round Bar 0.187"
Comment: Qty.: 0.2363 f(s)/Unit Total : 0.9450 f(s) 303 Round Bar 0.187" Batch: M103435		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: 1-TURN AS PER FOLIO FA113 & DWG D3147, FOLIO REV: _____ } new prog. DWG REV: _____		
2-DEBURR AS REQUIRED 		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Drill & mill as per Dwg D3147		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/05	4	One hole is not center.	 QS1042	Scrap, no replace	J.F. 07/04/05	 07/04/05	 QS1042	 07/04/05

NOTE: Date & initial all entries

Date: Tuesday, 03/04/2007 3:20:23 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 31578

Part Number: D31471

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 07/04/05 9

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1 Pin To B31168

Identify and Stock

8 Pin in stock CA

Location: _____

ml 07/04/09

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DX 07/04/11

Job Completion



U AT-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

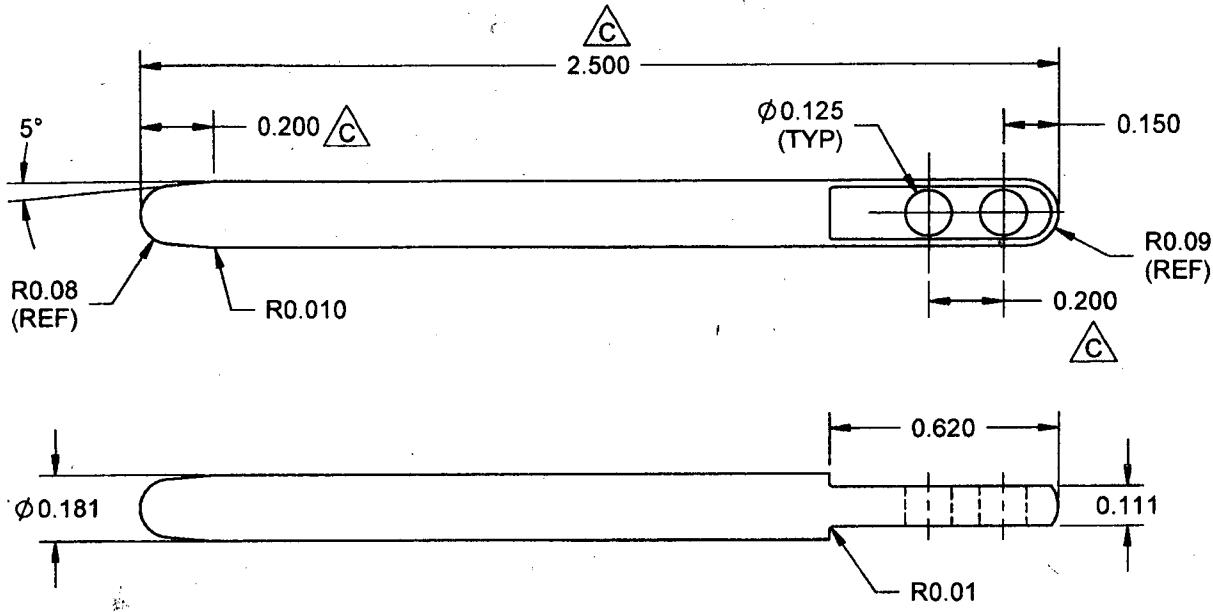
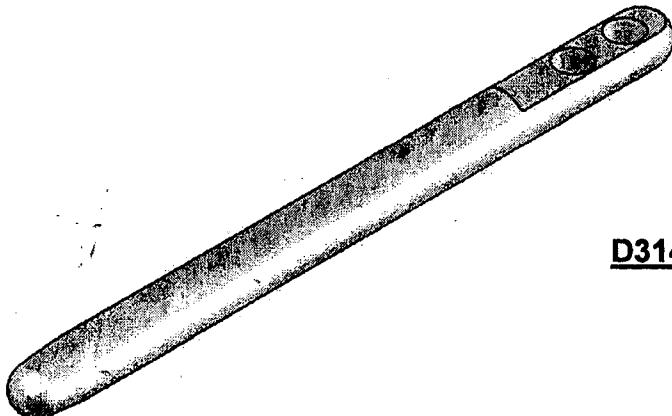
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>CE</i>	<i>SH</i>	D3147	SHEET 1 OF 1
DATE	06.12.04	TITLE	SCALE
		PIN	2:1
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND ϕ 0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	

**D3147-1 PIN****RELEASED**07.01.22 *[Signature]***NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

COPYRIGHT © 2002 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	31578
Description: Pin	Part Number:	D3147
Inspection Dwg: 13147	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article □ Prototype

Measured by: <u>S. P. J. S.</u>	Audited by: <u>M.S.</u>	Prototype Approval: <u>N/A</u>
Date: <u>07/04/04</u>	Date: <u>07/04/04</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	